

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004708**Date Inspected:** 19-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	NA	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b> Yes No N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b> Yes No N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b> Yes No N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b> Yes No N/A
				<b>Delayed / Cancelled:</b> Yes No N/A

**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

**Heavy Bay #3**

The QA Inspector performed initial random visual inspections of closed rib stiffener welds on deck panel DP466-001. The QA Inspector observed ZPMC and ABF representatives had completed visual inspections of these welds and they had identified portions of the welds that need rework. The initial inspections have been documented on the bottom of the yellow inspection status tag that is attached to the deck panel. The QA Inspector completed the initial visual inspections of the welds on this deck panel and documented the initial visual inspections on the bottom of the yellow inspection status tag that is attached to the deck panel.

The QA Inspector performed initial random magnetic particle visual inspections of closed rib stiffener welds on deck panels DP494-001, DP144-001. The QA Inspector observed ZPMC had completed visual inspections of these welds and they had identified the inspections on the yellow inspection status tag that is attached to each of the deck panels. The QA Inspector completed the initial visual inspections of the welds on these deck panels and documented the inspections on the yellow inspection status tag that is attached to each of the deck panels. See the TL6028 Magnetic Particle Test Report for additional information.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

Heavy Bay #1

This QA Inspector performed random final visual and ultrasonic (UT) inspections of tower lift 1 skin C welds NSD1-SA179B/E-1A/B, NSD1-SA179D/E-14A/B, NSD1-SA179D/E-10A/B, NSD1-SA179D/E-13A/B. The QA Inspector observed these four welds appear to comply with AWS D1.5 UT requirements. For additional information on these inspections see the TL6027 Ultrasonic Test Report.

**Summary of Conversations:**

See above.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

---